

Slip 20/01!

Work Order ID 111234
January-09-14 12:53:22 PM

D 4647-1
B 111234

111234

Item ID: D4647-1 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Doubler
Start Date: 09/01/2014 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 24/01/2014 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: DMC Date: 14-01-09 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4647	B								
110		0.00							
1110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-CUT AS PER DWG DWG REV: <u>B</u> PROG REV: <u>3</u>								
	2- Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
1120									
QC	Memo	0.00							
Quality Control									

9 0 Im14-01-15
9 0 Im14-01-15

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Item ID: D4647-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 09/01/2014 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 24/01/2014 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00				9			
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00				9			
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>ST116</u>	0.00				9x			
180									
Packaging	Memo	0.00							
Packaging									

DAS
27

9-89

0.00

14/1/16

DAS
28
9-89

14-01-17

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Item ID: D4647-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 09/01/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

14-01-17

14-01-17

Picklist Print

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Work Order ID: 111234

111234

Parent Item: D4647-1

D4647-1

Parent Item Name: Doubler

Start Date: 09/01/2014

Required Date: 24/01/2014

Start Qty: 8.00

Required Qty: 8.00

Comments: Ipp RevA 12.05.31 new issue EC verified by:JLM
13.07.17 AS PER DWG REV.B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased		No		110	sf	251.9500	0.125	②			
M6061T6S 040										**		Jm14-01-15	
6061-T6 .040 Sheet													

Location

Loc Qty

Loc Code

MAT021

251.95

m126350

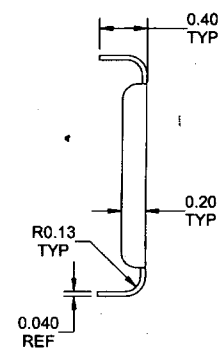
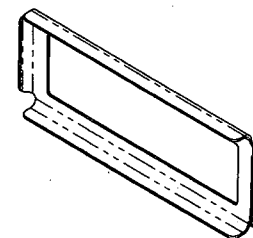
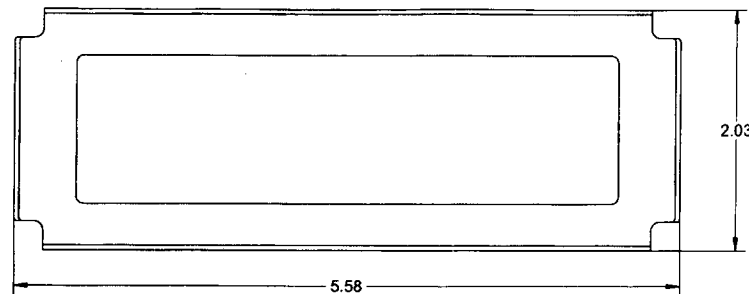
96

m126981

155.95

126350

111234
ML5
14-01-15



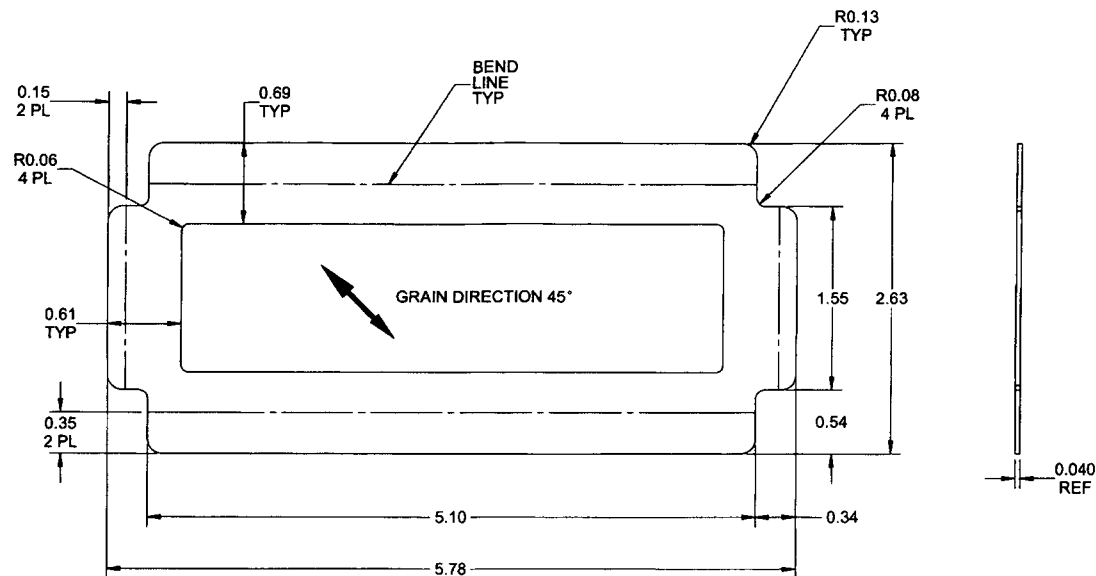
D4647-1 DOUBLER

RELEASED
2013-07-15
TW

NOTES:

- 1) MATERIAL: MAKE FROM D4647-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

B	REVISE D4647-3/3F (ZN B4-3, B4-4); ADD D4647-5 & -5F (ZN B4-5, C4-5); D4647-7/-8/-7F (ZN B4-6, B4-7, B4-8)	RF	13.06.18
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	DS	D4647	SHEET 1 OF 8
APPROVED	AS	TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	13.06.18	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4647-1F FLAT PATTERN DOUBLER

RELEASED
2013-07-15

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	NS	D4647	SHEET 2 OF 8
APPROVED	NS	TITLE	SCALE
DE APPR.	NS	DOUBLER	NTS
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